



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2892-1
Job Sheet 171313



Part No: D2892-1

Job Qty: 6 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 1/31/18

Job Tracking No:

Due Date: 2/7/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV B IPP C 02.11.26 Added P/O KJ IPP D 08.03.19 Re-format EC verified by: DD IPP Rev:E 11.08.04
as per dwg rev.B DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/6/18	0.00	0.00	Start Up Machining-1		<i>ML</i>
100	CNC Vertical Machining	6 pcs		2/6/18	0.36	5.08	HAAS1-2		<i>ML</i>
120	QC	6 pcs		2/6/18	0.00	0.00	QC8		<i>FK 18-2-6</i>
130	Crosstubes	6 pcs		2/7/18	0.00	0.97	Crosstubes-2		<i>AB FEB 06 2018</i>
140	QC	6 pcs		2/7/18	0.00	0.00	QC3		<i>PD 1802.07</i>
170	Packaging	6 pcs		2/7/18	0.00	0.00	Packaging3-1		<i>AB FEB 07 2018</i>
180	QC21-SA	6 Ea		2/7/18	0.00	0.00	QC21		<i>21 FEB 08 2018</i>

Part Op 100 - 1-Machine as per Folio FA082

Descriptions: 130 - Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.
24h of cure time *138381 exp 11/18*
170 - LOCATION : LG050

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK077	D2892-1 Turning Detail	3 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK077	3	0	0

5038670 - 5039245



Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5280
Email: sales@dartaero.com
www.dartaerospace.com



Support

PART NO: D2892-1

Original Serial #: S039250

Revision:

Operation: Start up Operation 02/05/18

Change No:

Job No: 171313

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
2	2.250 Support	0.290Inches + 0.020 - 0.000	0.310 0.290		
3	2.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
4	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
5	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
6	2.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
7	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
8	2.250 Support	1.116Inches + 0.040 - 0.000	1.156 1.116		
9	2.250 Support	0.454Inches + 0.020 - 0.000	0.474 0.454		
10	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
11	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
12	2.250 Support	0.257Inches + 0.005 - 0.000	0.262 0.257		
13	2.250 Support	1.663Inches + 0.020 - 0.000	1.683 1.663		
14	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
15	2.250 Support	0.022Inches + 0.020 - 0.000	0.042 0.022		
16	2.250 Support	2.779Inches + 0.010 - 0.000	2.789 2.779		

Plex 1/31/18 7:17 AM dart.leroux.jason

DART AEROSPACE LTD		Work Order:	
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.150		.135	.137	.137	.136	.137
AB	0.290	0.310		.305	.302	.305	.305	.308
AC	0.040	0.060		.046	.045	.049	.050	.051
AD	0.115	0.150		.130	.132	.124	.126	.129
AE	0.240	0.260		.248	.247	.248	.249	.244
AF	0.188	0.193		.190 Ø	.190 Ø	.190 Ø	.190 Ø	.190 Ø
AG	0.240	0.260		.250 R	.250 R	.250 R	.250 R	.250 R
AH	1.116	1.156		1.136	1.138	1.136	1.136	1.137
AI	0.454	0.474		.470	.469	.471	.472	.471
AJ	0.240	0.260		.250 R	.250 R	.250 R	.250 R	.250 R
AK	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AL	0.257	0.262		.261 Ø	.261 Ø	.260 Ø	.260 Ø	.260 Ø
AM	1.663	1.683		1.676	1.676	1.678	1.677	1.677
AN	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AO	0.022	0.042		.032 R	.032 R	.032 R	.032 R	.032 R
AP	2.779	2.789		2.783	2.783	2.783	2.783	2.783
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: <u>MM</u>	Date: <u>2014/02/05</u>
Audited by: <u>FK</u>	Date: <u>18-2-6</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	
D	13.05.22	Dimensions updated	KJ	<u>AS</u>

DART AEROSPACE LTD		Work Order:	
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	0.115	0.150		.135				
AB	0.290	0.310		.303				
AC	0.040	0.060		.053				
AD	0.115	0.150		.126				
AE	0.240	0.260		.248				
AF	0.188	0.193		.190				
AG	0.240	0.260		.250 R				
AH	1.116	1.156		1.133				
AI	0.454	0.474		.465				
AJ	0.240	0.260		.250 R				
AK	0.053	0.073		.063 R				
AL	0.257	0.262		.260				
AM	1.663	1.683		1.676				
AN	0.053	0.073		.063 R				
AO	0.022	0.042		.032 R				
AP	2.779	2.789		2.782				
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: MM 2018/02/05 **Date:** _____

Audited by: FK **Date:** 18-2-6

Preliminary Approval: _____ **Date:** _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	
D	13.05.22	Dimensions updated	KJ	<u>MM</u>